

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008441**Date Inspected:** 09-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#2- Segment 1AAW

This QA inspector witnessed MT of seg1E stiffeners weld removal areas. ZPMC QC found an linear indications.

This QA inspector witnessed MT of seg1E stiffeners excavated areas in base metal. ZPMC QC-CWI Li Zhi Jiang and ABFJV Wang Wen Bin were present during observation. The weld joint numbers are designated as below.

-(Seg1F-023, 024, 025, 026)

-(Seg1E-043, 044)

-(Seg1E-254+164)

-(Seg1C-026)

-(Seg1E-152+242)

-(Seg1C-050)

-(Seg1E-362+320)

-(Seg1C-128)

-(Seg1E-148+238)

-(Seg1C-058)

-(Seg1E-353+311)

-(Seg1D-146)

-(Seg1E-137+227)

-(Seg1D-150)

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-(Seg1E-347+305)
-(Seg1D-128)
-(Seg1E-341+299)
-(Seg1D-108)
-(Seg1E-340+298)
-(Seg1D-105)
-(Seg1E-422+380)
-(Seg1D-107)
-(Seg1E-337+295)
-(Seg1D-096)
-(Seg1E-045, 046, 334)
-(Seg1F-002, 003, 004, 005)

During random verification Magnetic Particle Testing of the internal components of OBG Segment 1AAW, Caltrans Quality Assurance (QA) Inspector discovered a total of (11) eleven, linear indications from 05mm to 35mm in length in the base metal (weld removal area) plate detail X199A. These welds have been previously tested and accepted by ZPMC Quality Control MT Technicians. This QA Inspector generated TL015 Incident report for these indications.

During random verification Magnetic Particle Testing of the internal components of OBG Segment 1AAW, Caltrans Quality Assurance (QA) Inspector discovered a total of (5) five, linear indications from 05mm to 15mm in length in the base metal (weld removal area) plate detail X182B. These welds have been previously tested and accepted by ZPMC Quality Control MT Technicians. This QA Inspector generated TL015 Incident report for these indications.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
